

Work Order ID 153981***153981***

Page 1

Wednesday, November 30, 2016 4:01:55 PM

Item ID: D3794-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Aft

Start Date: 11/29/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/30/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: DEC 01 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.06

FLOW CNC Waterjet

1-Cut as per Dwg D3794 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary6Dec 16/12/03

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

6Dec 16/12/03

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.02

Quality Control

6DAS 38
DEC 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 153981

Wednesday, November 30, 2016 4:01:55 PM

153981

Page 2

Item ID: D3794-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Aft
 Start Date: 11/29/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/30/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130						4			
Packaging		0.01							
Packaging	Memo LOCATION : FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
6
9-89

DEC 05 2016

16/12/16

MF
16-12-06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Wednesday, November 30, 2016 4:01:55 PM

Page 1

Work Order ID: 153981

153981

Parent Item: D3794-3

D3794-3

Parent Item Name: Gasket Aft

Start Date: 11/29/2016

Required Date: 11/30/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	124.9668	1.2828	8.552			

MNEO60S 063

NEOPRENE SHEET 0.063

**

on 11/12/03

Location

Loc Qty

Loc Code

MAT

112.1

M135551

112.1

MAT052

12.866778

M134972

12.866778

6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

DART AEROSPACE LTD		Work Order:	153981
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

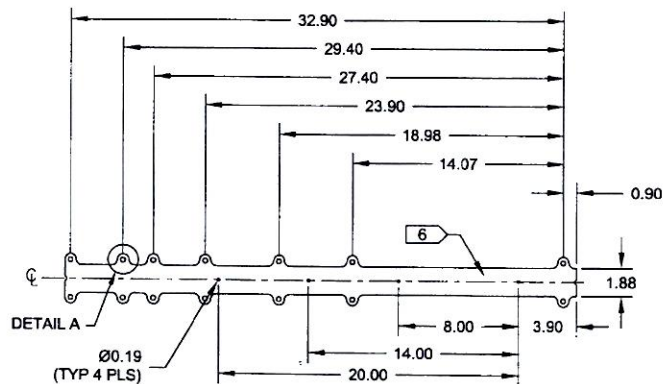
☒ **First Article**

 ☐ **Prototype**

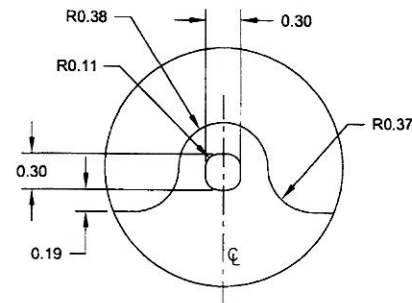
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø.19	✓		Tape	
0.300 x 0.300	+/-0.010	.305 x .305	✓		V: DC-01	
1.88	+/-0.030	1.88	✓			
4.281	+/-0.010	4.281	✓			
6.44	+/-0.030	6.44	✓			
6.00	+/-0.030	6.00	✓			
6.75	+/-0.030	6.75	✓			
2.00	+/-0.030	2.00	✓			
4.75	+/-0.030	4.75	✓			
9.50	+/-0.030	9.50	✓			
14.25	+/-0.030	14.25	✓			
17.75	+/-0.030	17.75	✓			
26.74	+/-0.030	26.74	✓			
29.23	+/-0.030	29.23	✓			

Measured by:	DC	Audited by:	38 9-89	Prototype Approval:	N/A
Date:	16/12/13	Date:	DEC 05 2016	Date:	N/A

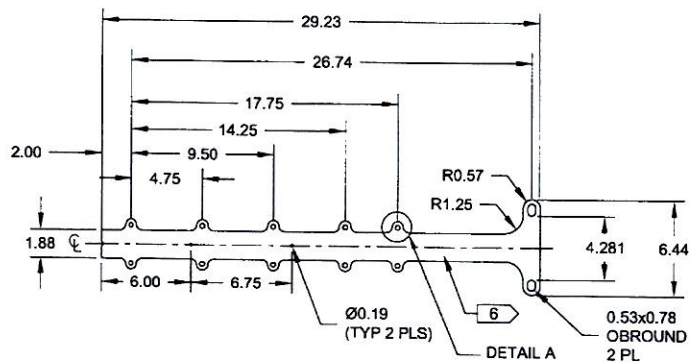
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153981 MJS
16-12-01

RELEASED
08-05-14

REV	DESCRIPTION	PH	DATE
A	NEW ISSUE	BY	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3794	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	NTS
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